

Work Order ID 74242

Tuesday, September 27, 2011 11:46:29 AM



Page 1

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Hinge

Start Date: 9/27/2011 Start Qty: 48.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 48.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4073

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

mlh 11/09/27

48

Ø

Jeaspa Bandsaw

cut blank 4.563" long

105

0.00



HAAS I

Memo

0.00

mlh 11/09/28

48

Ø

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev: *AB*

Folio Rev: *AA*

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				48	0		
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				45			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				48			BR 10-4-08.

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QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

0.00

Start Time: 10:10
Temp: 3200F
Finish Time: 10:40

48^x m/11/09/29

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

48 f M u d o d z q
coat

180

Identify as per dwg & Stock Location: 120

0.00



Packaging

Memo

Packaging

0.00

11k29sf 48

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Run Start



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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3

MF

11-09-29

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Picklist Print

Tuesday, September 27, 2011 11:46:26 AM

Page 1

Work Order ID: 74242



Parent Item: D4073-1



Parent Item Name: Door Hinge

Start Date: 9/27/2011

Required Date: 10/7/2011

Start Qty: 48.00

Required Qty: 48.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	25.3416	0.38	19.2			



6061-T6 Bar 2.00 x 1.25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	25.34163158	
114899	4.15263158	
116623	2.15	
→ 118641	19.039	

19.2 *ml 11/09/27*

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DART AEROSPACE LTD		Work Order: 74242
Description: Door Hinge		Part Number: D4073-1
Inspection Dwg: D4073	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	R.03	/		R-6	
Ø0.203	+0.005/-0.001	Ø.204	/		Vern 10-06	
2.00	+/-0.030	2.000	/		"	
0.81	+/-0.030	.808	/		"	
0.350	+/-0.010	.350	/		"	
1.100	+/-0.010	1.100	/		"	
Ø0.500 x 0.125	+/-0.010	Ø.503 x .124	/		"	
0.340	+/-0.010	.340	/		"	
1.320	+/-0.010	1.320	/		"	
4.44	+/-0.030	4.440	/		"	
4.13	+/-0.030	4.130	/		"	
R0.31	+/-0.030	R.310	/		"	
0.313	+/-0.010	.313	/		"	
0.63	+/-0.030	.625	/		"	
1.00	+/-0.030	1.000	/		"	
0.38	+/-0.030	.376	/		"	
0.190	+/-0.010	.192	/		"	
1.80	+/-0.030	1.801	/		"	
0.25	+/-0.030	.250	/		"	
R0.13	+/-0.030	R.130	/		"	

Measured by: <i>and</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 11/09/27	Date: 11/9/28	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

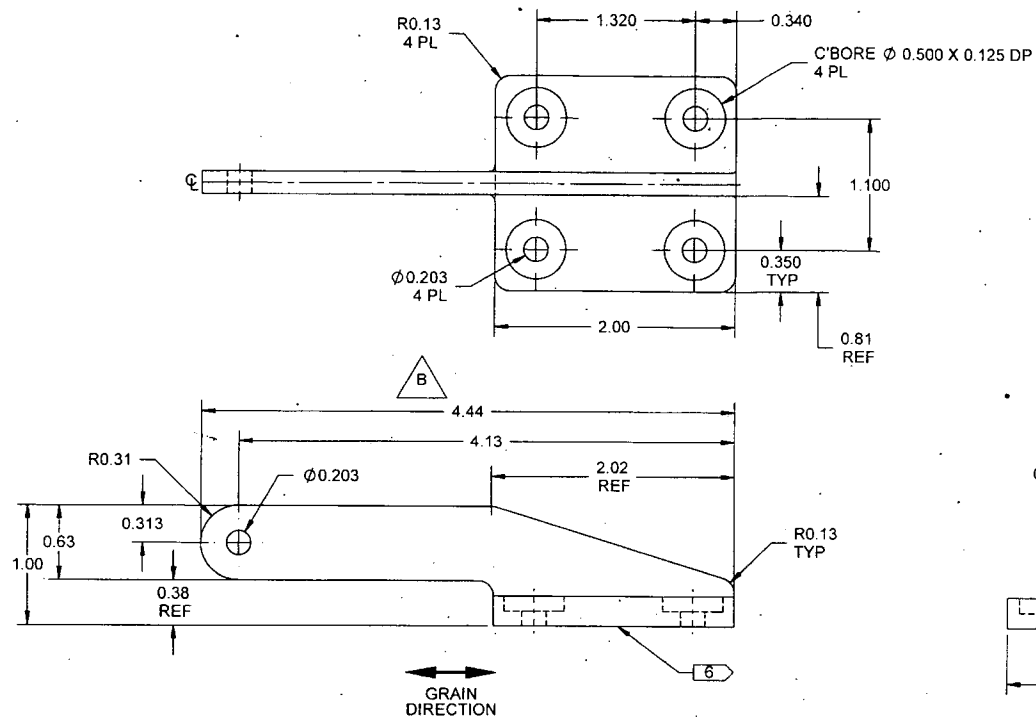
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D4073-1 DOOR HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.05.02		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D4073	REV. B SHEET 1 OF 2
TITLE DOOR HINGE	SCALE NTS

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RELEASED
2011-06-30
[Signature]

Wlo 7/2/12

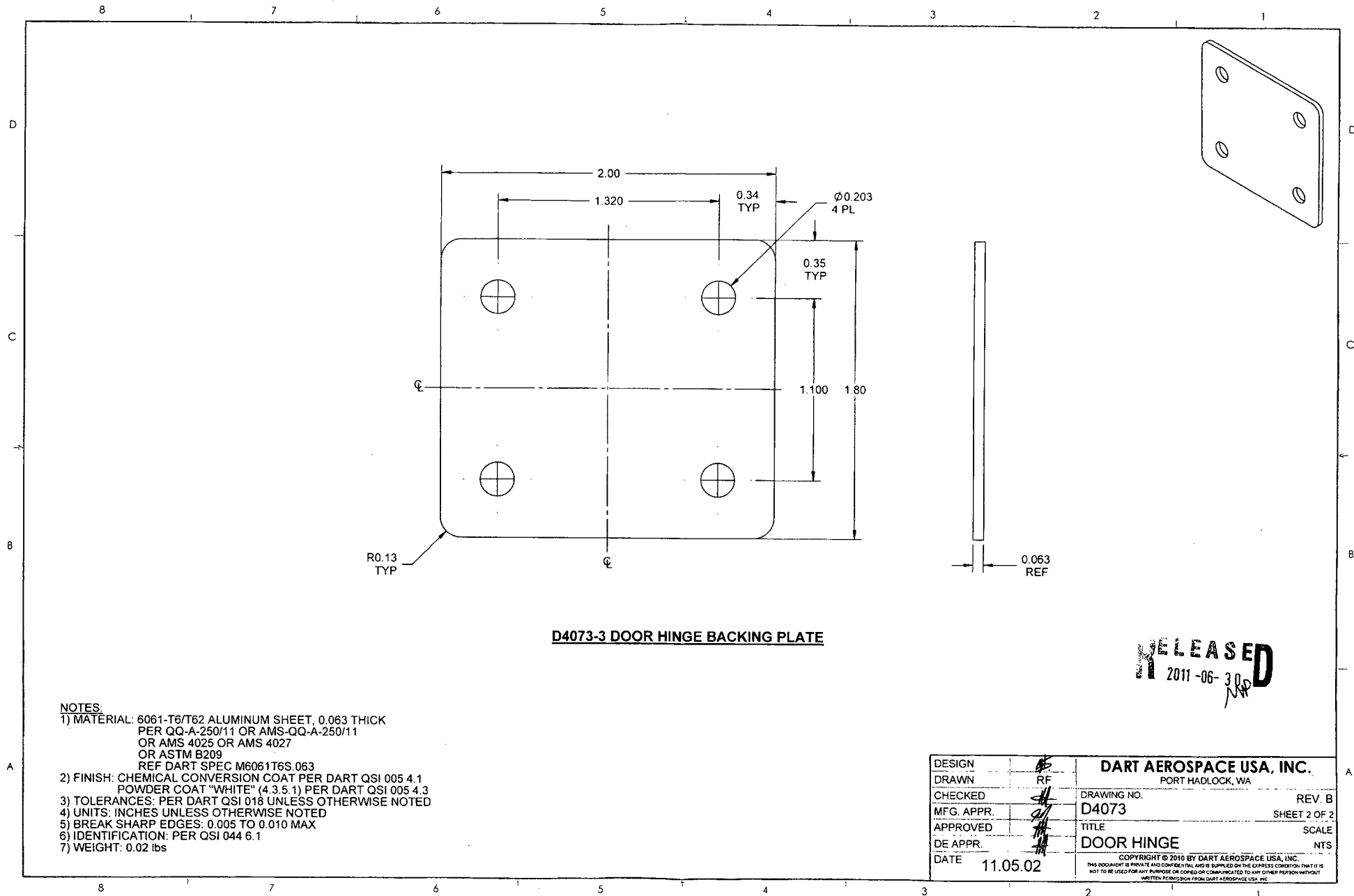
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